Work Order ID 102943 Page 1 June-12-13 9:17.10 AM Item ID: D3200-3 Accept *N900040100* Setup Start **Revision ID:** Door Wedge Item Name: **Start Qty: 16.00** 6/11/13 **Start Date: Cust Item ID:** Required Date: 6/11/13 Req'd Qty: 16.00 **Customer:** Reference: Run Date: $\frac{1}{3}$ - $\frac{1}{3}$ Tooling: Process Plan: M 5 Date: **Approvals:** SPC (Y/N): Date: Date: Tool # Plan Reject Reject Insp. Sequence ID/ Tool ID Accept Operation Set Up/ Number Stamp Code **Qty Qty** Work Center ID **Description Run Hours** Draw Nbr **Revision Nbr** D3200 Rev A 100 0.00 MH 13/06/23 16 Ø **BAND SAW** *100* 0.00 Bandsaw Memo Jeaspa Bandsaw Cut blank: 1.000 X 1.970" DR BA 13/07/15 16 B 0.00 110 HAAS CNC VERTICAL MACHINING #1 *110* 0.00 HAAS 1 Memo 1-Machine D3200-3 as per Folio FA337 and Dwg D32002-Deburr HAAS CNC vertical machine #1 18/3/07/15 16 \$ 0.00 120 QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Quality Control

QC

DQA: QA Closed: Work Order:	Auto No.	Date:	1	118	WORK ORDER NOT DISPOSITION Rework	N-C(RMANCE / UF		ork Order up PARTMENT,		DART AEROSPACE
Part No. <u>D3200-3</u> NCR No. <u>\3-2850</u>				Scrap	Scrap Machining N Small Fab Use-as-is Thermoforming Finishing			Small Fab Finishing Composite	Prod. Eng. Coor. Qua Rec/Store/Packaging Ot Supplier			
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance	- 1	Initial nief Eng	Acti	ion iption	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	137115	33	16		'SINK IS UNDER L. \$0.385 Operator Error. It was not beverlien	13	47/15	Accepte MSZ4693 still Flu		47 17/15	(3/07/15	16 16 9-89 Blozlib
Landing	Goor				Ganaral	FA	ULT CA	TEGORY			···	
Landing	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch Turning S Wave/Tw	nk/Ripple at n Strip in natter equence	:/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function		Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set	ion Incomplete/Ur tions Incomplete/U gned/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other

Work Ord June-12-13 9:1		2943		*102943*									
Item ID: Revision ID: Item Name: Start Date:	D3200-3 Door Wedge 6/11/13	Start Qty: 16.00	*16*	Accept		J900 Cust Item I		100)* s	etup S	tart top		S1* S2*
Required Date Reference:	: 6/11/13	Req'd Qty: 16.00	*16*		ı	Customer:							
Approvals:	Process Pla	nn:	Date:	Tooling:		Da	ite:		R		tart top	*N	R1*
	QC:		Date:	SPC (Y/N):		Da	ıte:				top	*N	R2*
Sequence ID/ Work Center I	D	Operation Description	, ·	Set Up/ Run Hours	3	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp
*130 *130* QC Quality Control		QC8- Inspect parts - seco	на спеск	0.00) ^A S 40 9-89	13/07/	5		16	Ø			
140		Identify as per dwg & Sto	ock Location: <u>STO</u> 33	0.00								1	
140 Packaging Packaging		Memo		0.00					16x		<u>M</u> .	. KV. 1	3-07-16
150		QC21- Final Inspection -	Work Order Release	0.00						12		1/1	1
150 QC Quality Control		Memo		0.00					ς,			MC	3-7-16

DQA:			Date:			- Wary apper you conservance (URDATE									
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UI		Work	Order un	date only	AEROSPACE	
QA Closeu.			Dute.				П			*		· · · · · · · · · · · · · · · · · · ·			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	_				_	Rework			Skid-tube	Crosstube		Water Jet Engineering			
Part No.				Scrap		ı	Machining	Small Fab		Prod	d. Eng. Coor.	Quality			
				· Use-as-is]	Thern	noforming	Finishing		Rec/Stor	e/Packaging	Other			
NCR No.				Suspected Unapproved]		Large Fab	Composite			Supplier	J ∐			
						لـــ					c: 0				
Root		D.A.		04	Desc	ription of work order update	1	nitial	Act			Sign &	Verification	OCInchestor	
Cause		Date	Step	Qty		or non-conformance	Cn	ief Eng	Descr	iption	+	Date	vermeation	QC Inspector	
Design Doc/Data	H													`	
Equip/Tooling	Н														
Handling/Pre															
Material	H														
Operator	\vdash														
Offset/Setup	П														
Process	П														
Supplier	П														
Training							1								
Transport															
Unapproved						· ·	<u> </u>								
					-	· ·	FAI	ULT CA	TEGORY						
Landi	ng G					General		1							
	Ш	Bending			<u> </u>	Bend	_	ł' '	Program	1		utside Dim	 	Pressure/Forced	
	Щ	Centre N	ot Concer	ntric		BOM/Route	_	Grain				ver/Under	├	Set-up	
		Cracks			<u> </u>	Broken/Damage/Defect	-	Hardwa	•			art Incorred	-	Temperature/Cure	
	-	Crimp/Kii	nk/Ripple	:/Wave		Burrs	-	1	ion Incomplete/Ur			art Lost/Mi	ssing	Weld	
		Cuffs			-	Contamination		4 '	tions Incomplete/l	Jnclear		art Moved	L	Wrong Stock Pulled	
	<u> </u>	Crushing			. -	Countersink		4.	gned/off center	}		ositioned V		704	
	\vdash	Heat Trea		Tt	\vdash	Cut Too Short	\vdash	Mislabe		Ĺ		ower Loss/	Surge	Other	
	-	Inspectio	•	rube	-	Drawing Drill Holes	-	Misrea			_				
	\vdash	Marks/Ch				Finish	\vdash	Off-set			_				
	-	Turning S Wave/Tw			-	Fit/Function	\vdash	4	Calibration Sequence		_				

Picklist Print

June-12-13 9:17:10 AM

Work Order ID:

102943

Parent Item:

D3200-3

Parent Item Name:

Door Wedge

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	815.0950	0.015	0.252632			
UHMW 1" Black									C> // B				

Location	Loc Oty	Loc Code		
MAT019	815.0949895			i la s
- 121278	12.0949895		400 × 3526	MH 13/06/23
122575	47.6			
123229	53			
123704	63.8			
123949	6.96			
124382	197.12			
124758	34.52			
125137	400			

DQA:		Date	e:										
QA Closed:		Date	e:		WORK ORDER NON-	-C(ONFO	RMANCE / UP	DATE	Wo	ork Order up	date only	AEROSPACE
Work Orde	ır.				DISPOSITION				AGAINST	DE	PARTMENT	PROCESS	
WOIR Olde					Rework	1	Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo			·	Scrap				Machining Small Fab			d. Eng. Coor.	Quality
NCR N	NCR No.				Use-as-is Suspected Unapproved		Thermoforming Finishin Large Fab Composit			- 			Other
Root				Desc	ription of work order update	otion of work order update Ir			on		Sign &		
Cause	Da	te Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling						1							
Handling/Pre													
Material													
Operator						Ì							
Offset/Setup			.]			İ							
Process			ŀ										
Supplier				ŀ									·
Training													
Transport													
Unapproved													
						FA	ULT CA	TEGORY					
Landi	ng Gear				General						_	_	
	Bend	ing			Bend	<u></u>	Folio/F	Program	•		Outside Dim	ensions	Pressure/Forced
	Centi	e Not Cond	entric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Crack	:S			Broken/Damage/Defect		Hardwa	are		L	Part Incorred	ct _	Temperature/Cure
	Crim	o/Kink/Ripp	ole/Wave	· L	Burrs		Inspect	ion Incomplete/Un	qualified	L	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruc	tions Incomplete/U	nclear	L	Part Moved		Wrong Stock Pulled
	Crusł	ning			Countersink		Misali	gned/off center			Positioned V	Vrong	
	Heat	Treat			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
	Inspe	ction Strip	in Tube		Drawing		Misrea	d					
,	Mark	s/Chatter			Drill Holes		Off-set						
	Turni	ng Sequen	ce		Finish		Out of	Calibration					
	\square_{Wav}	/Twist in T	uhe		Fit/Function		Out of	Saguence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	102943
Description: Door Wedge	Part Number:	D3200-3
Inspection Dwg: D3200 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

FIRST ARTICLE INSPECTION CHECKLIST										
	X	First Arti	icle	Prof	totype					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
Ø0.196	+0.005/-0.000	.196			18 05	6"ULEN				
0.405 x 100°	+/-0.010	401			DP05	,				
0.500	+/-0.010	.499			DROS					
1.722	+/-0.010	1.724			DEOT					
0.380	+/-0.010	.378			NS 02					
0.975	+/-0.010	975		·	DROS					
0.750	+/-0.030	745			1205					
0.015 - 0.050	N/A	.01			X805	6" VERN.				
		· · · · · · · · · · · · · · · · · · ·								
			DAS							
Measured by:	P. D.A.	Audited by:	40	ŀ	Prototype App	roval: N/A				
Date:	3/07/15	Date:	13/07/1	5		Date: N/A				

Rev	Date	Change		Revised, by	Approved
A	03.11.12	New Issue	P/O D412-698-015	KJ/RF	74

